

Work Order ID 63576

Thursday, November 04, 2010 1:08:00 PM



Page 1

Item ID: D2528-1

Accept



Setup Start



Revision ID:

Item Name: Backer Plate

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

DP

Date: 10-11-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2528

Rev C1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2528 ☐ Dwg Rev: C1 ☐ Prog Rev: C1 ☐ 2-
Deburr if necessary

0652 - 063

B10-11-29

14

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/21/13

214

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Backer Plate					
Start Date: 11/4/2010	Start Qty: 12.00		Cust Item ID:		
Required Date: 11/12/2010	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		1011130		14	Ø		
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 115951 Memo START TIME: 10:15 320°F FINISH TIME: 10:45	0.00 0.00				14	Ø	10-12-1	
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10112101		14	Ø		

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Accept



Setup Start



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Stop



Item Name: Backer Plate

Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 16

0.00



Packaging

Memo

0.00

Packaging

10/12/11 SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/02
MF
10-12-01

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 1:08:04 PM

Page 1

Work Order ID: 63576

Parent Item: D2528-1

Parent Item Name: Backer Plate



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: ☐ C ☐ 00.06.26 ☐ Removed P/O for powder coat ☐ EC ☐
IPP Rev:D 08-07-23 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063 		Purchased											
5052-H32 .063 Sheet													

Location

Loc Qty

Loc Code

MAT

159.5

114322

159.5

MAT22

6.17

112442

6.17

112442

14

15
1810-11-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	43574
Description: Backer Plate		Part Number:	D2528-1
Inspection Dwg: D2528 Rev: C1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	.258	✓		V HB02	
0.50	+/-0.030	.500	✓		V	
1.46	+/-0.030	1.462	✓		V	
0.81	+/-0.030	.811	✓		V	
1.62	+/-0.030	1.624	✓		V	
2.46	+/-0.030	2.466	✓		V	
0.063	+/-0.010	.063	✓		V	

Measured by: JB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-11-29	Date: 10/11/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.03.10	New Issue	KJ/DD [Signature]	[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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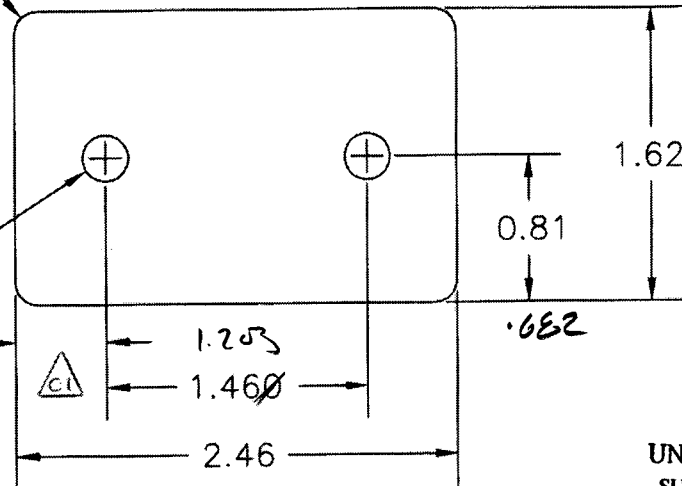
NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

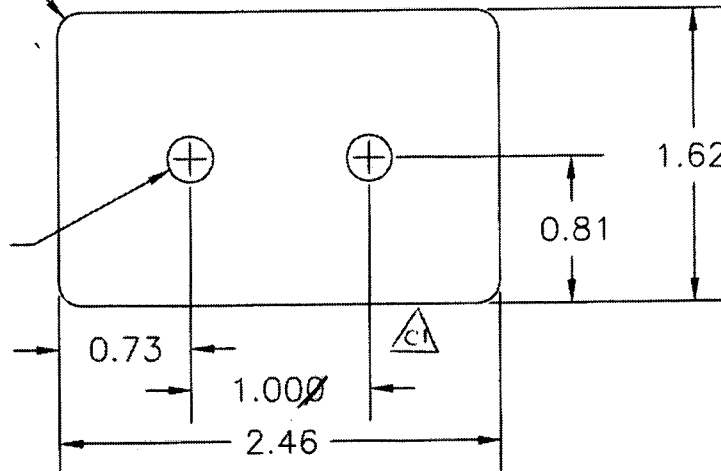
RELEASED
98.12.11 *KE*

R0.13 (TYP)

UNDER REVIEW*OK 03.12.03*Ø0.257 (TYP)
.1250.50
.371D2528-1SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63574

R0.13 (TYP)

Ø0.257 (TYP)

D2528-3

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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